

Date: Monday, 05/03/2007 12:34:27 PM  
 User: Linda L. acelle

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: MOUNTING LUG
Job Number	: 30993		
Estimate Number	: 10256		
P.O. Number	: <i>N/A</i>	Part Number	: D22303
This Issue	: 05/03/2007 S.O. No. : <i>N/A</i>	Drawing Number	: D2230 REV F
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 01/03/2007 Type : MACHINED PARTS	Drawing Revision	: F
Previous Run	: 30545	Material	: <i>N/A</i>
Written By	: <i>[Signature]</i>	Due Date	: 03/12/2007
Checked & Approved By	: <i>[Signature]</i>	Qty:	<i>60</i> Um: Each
Comment	: Est D 00.05.18 Added inspection level 8, and removed P/O for powder coat EC		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D2423	Lug Extrusion
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Comment: Qty.: 0.0717 f(s)/Unit Total: 71.7150 f(s)  
 Lug Extrusion  
 D2423  
 Batch: *B 30062*

2.0	BAND SAW	BAND SAW
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Comment: Band Saw  
 Cut D2423 extrusion to 0.82"  
 Batch: \_\_\_\_\_

3.0	PG	PURCHASING
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Comment: PURCHASING  
 Issue P/O *BLKT00001*  
 Possible Supplier: Metec  
 Machine per Drwg D2230 Rev. F

*30 - June 12, 2007*  
*124 - June 15, 2007*  
*60 - June 18, 2007*  
*C 207103108*

*1000* *[Signature]*

4.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1  
 Receive & Inspect for transit damage

*EP 07/06/18* *(60)*

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Drawing Name: MOUNTING LUG

Job Number: 30993

Part Number: D22303

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*Handwritten:* 07/06/19 (460)

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Tumble and deburr rough edges after tumbling

*Handwritten:* 07/06/24 60 Counted

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

*Handwritten:* M-L 07/07/05

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*Handwritten:* 07-07-05

9.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Gloss White (ref. 4.3.5.1) per Dart QSI 005 4.3

*Handwritten:* M 101 575

*Handwritten:* BR/FZ. 07-07-05

*Handwritten:* (60X)

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/INSPECT POWDER COAT

*Handwritten:* 07-07-05

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

*Handwritten:* 07/07/09 (60)

12.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*Handwritten:* 07/07/09 (60)

Job Completion

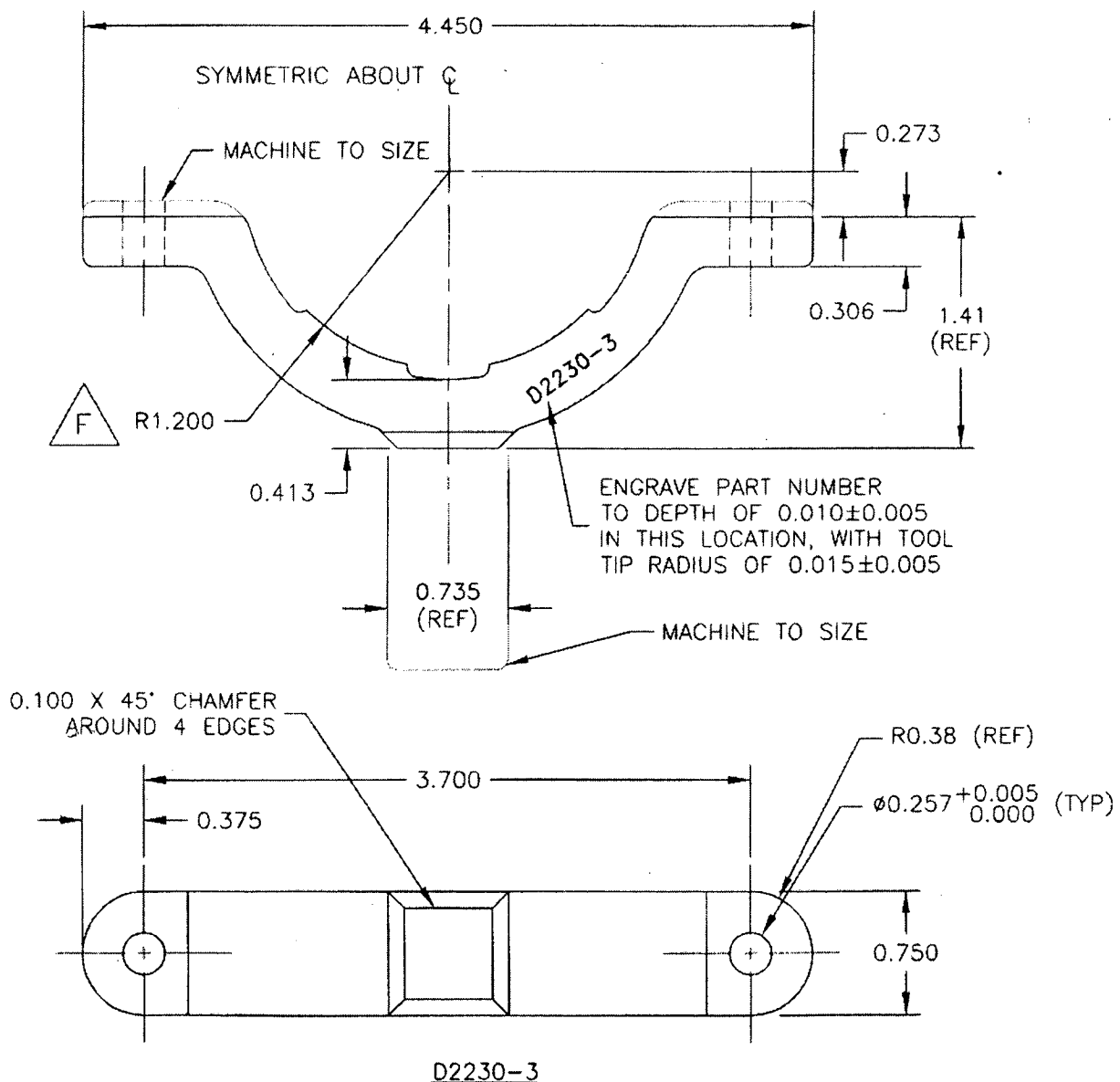


*Handwritten:* 07/07/09



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2230	REV. F SHEET 2 OF 2
DATE 99.12.13		TITLE MOUNTING LUG	SCALE 1:1

RELEASED  
19.12.11 DS



MAKE FROM EXTRUSION D2423  
BREAK ALL EDGES 0.000-0.015  
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED